

14

Date: Tuesday, 3/11/2008 7:54:56 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE ASSEMBLY
 Job Number : 37731
 Estimate Number : 10022
 P.O. Number :
 This Issue : 3/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1 / Type : LANDING GEAR
 Previous Run : 37730
 Written By :
 Checked & Approved By : 08 03 11
 Comment : Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ

Part Number : D205634011
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : N/A
 Material :
 Due Date : 4/4/2008 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011

CHG005

08/04/21 08/03/26

2.0 37731A SKID TUBE ASSEMBLY



Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 37731A

SP

8/4/21

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 K10003 D205-634-011 Saddle Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit

B37280

08/4/21 (1)

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/21 (4)

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location:

08/4/21 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:54:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 37731

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.04.22

B 37731A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:55:16 AM
 User: Kim Johnston

Process Sheet

14

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY
 Job Number : 37731A
 Estimate Number : 10023
 P.O. Number :
 This Issue : 3/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LANDING GEAR
 Previous Run : 37730A
 Part Number : D205634041
 Drawing Number : D2580 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 4/4/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JA 08 03 11
 Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 Est Rev. O 06.02.28 Added paperwork EC
 Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG002

N/A JA

2.0 D25001190

Ext'n -1" Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B 29602

JO 8-3-13

3.0 D2596

205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	B 37253

a.m

08.03.24

①

4.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

3-Acid etch and Alodine tube per QSI 005 4.1

JO 8-3-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:55:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 37731A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m. 08.03.19 ①

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill-pilot holes using drill jig DT 8149(Do not use cutting fluid)

a.m. 08.03.24 ①

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

a.m. 08.03.24 ①

3-Countersink holes as per Dwg D2580without cutting fluid

a.m. 08.03.24 ①

4-Deburr and blow out all chips from inside of tube

a.m. 08.03.24 ①

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

a.m. 08.03.24 ①

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 m107377

a.m. 08.03.24 ①

Sikaflex expire date: 10-08

Start Time: 7:30 Date: 8-3-24

Fin Time: 9:00 Date: 8-4-2

7.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL/JP8-4-2

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

) K 8-4-2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:55:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 37731A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 08/04/03

10.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2576-3

Step

BE 33321

BE 08/04/03

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

20

D2579

Spacers

BE 37856-1

BE 08/04/03

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

BE m106762

BE 08/04/03

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

BE m106762

BE 08/04/03

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

SL 8-4-4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:55:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 37731A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC5

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-08 / 08/04/08 (C)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/08 (C)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

HA 08-04-09 (X)

16.0

POWDER COATING

POWDER COATING



M107550



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/04/09

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-04-10 (D)

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: B35683

BR

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M10688

BR

20.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M104885

BR

BR 08-04-10 (D)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:55:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 37731A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

21.0	ALS71032130	Insert
------	-------------	--------



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch: M105855

BR.

22.0	AN3C4A	BOLT
------	--------	------



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch: M107376

BR.

23.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

Batch: M107376

BR.

24.0	D356613	GASKET
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B32744

BR.

25.0	D35665	GASKET
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B37411

BR.

26.0	D35661	GASKET
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B38048

BR.

27.0	D356413	WEARSHOE
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B37561

BR.

08-04-10 0.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:55:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 37731A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

* 28.0

D356411

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B37213

BL.

29.0

D35649

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B37812

BL

30.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B38297

BL

31.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch: B29908

BL

32.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch: B37419

BL

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date:

11/07397
08-10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

BL 08-04-10

BL 08-04-10

①.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:55:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 37731A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

M107397
08-10

BK 08-04-10 (D)

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M107385

=> 08-04-11 (X1)

34.0

QC5

INSPECT WORK TO CURRENT STEP



Good to go



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

PP 37731

Shelvis sq (A)

36.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/22 (J)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/04/22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 [Signature]

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

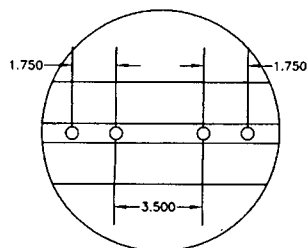
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37731A

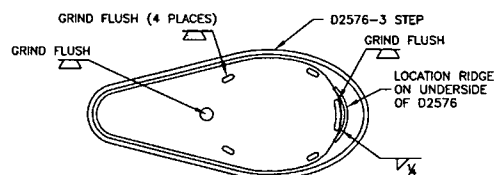
Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

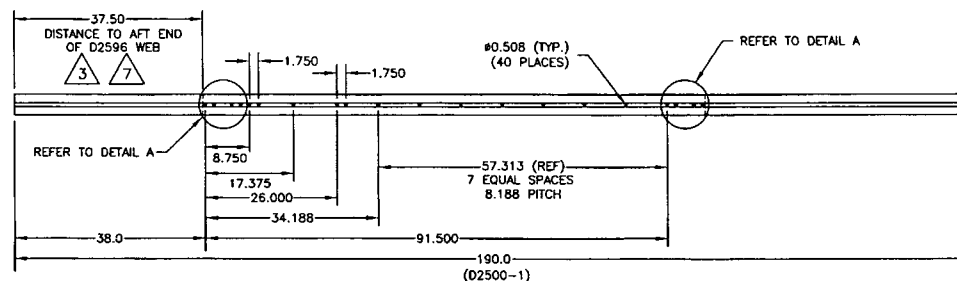
DETAIL A
SCALE 5:24



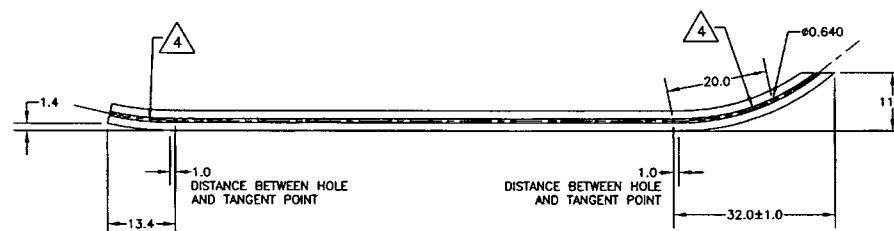
DETAIL B
SCALE 5:24



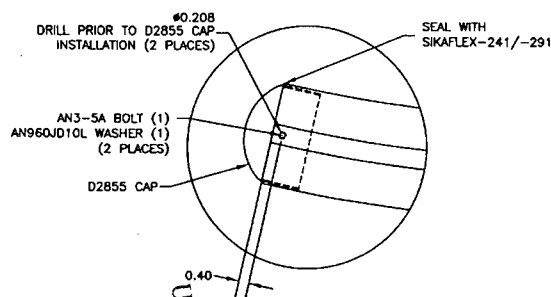
D2580-1 DRILLING DETAIL



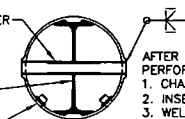
D2580-1 BENDING AND CUTTING DETAIL



DETAIL C
SCALE 5:24

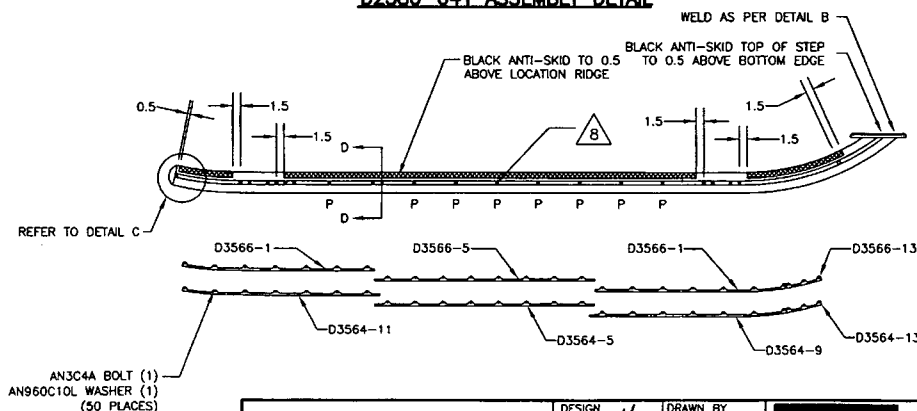


SECTION D-D
SCALE 5:24



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (20 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C-BORE D2579 SPACER TO #0.437 X 1.00 DEEP

D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

COPYRIGHT © 1996 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580	REV. 0
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SHEET 2 OF 3 SCALE 1:24

RELEASED
07 Dec 28

Diagram illustrating the grinding locations for the propeller cross-section. The diagram shows a cross-section of a propeller with the following labeled areas:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- GRIND FLUSH

DRILL PRIOR TO D2855 CAP
INSTALLATION (2 PLACES)

SEAL WITH
SIKAFLEX-241/-291

AN3-SA BOLT (1)
AN960JD10L WASHER (1)
(2 PLACES)

SEE NOTE ii)

D2855 CAP

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NO. 37231A

WORK ORDER

SHOP COPY
RETURN TO
ENGINEERING

SECTION H-H
SCALE 5:24

D2579 SPACER

D2596 WEB (REF)

ALST-1032-130 (REF)
(TYP 50 PLACES)

AFTER DRILL
PERFORM
1. CHAMF
2. INSERT
3. WELD
4. C'BOR

D2579 SPACER

WEB (REF)

130 (REF)

10 PLACES

AFTER PERFORM

1. CHA
2. INS
3. WEL
4. C'B

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

37.50
DISTANCE TO AFT END
OF D2596 WEB

3
7

1.750 1.750

0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

38.0

91.500

190.0
(D2500-1)

(MAKE FROM D2580-1 DRILLING DETAIL)

5.985
1.4
5.338 (REF)
51.340
39.580
5.915
3.630 (REF)
Ø0.508 (8 PLACES)
Ø0.640
20.0
11.0
1.0
32.0 ± 1.0
1.0
13.4
DISTANCE BETWEEN HOLE AND TANGENT POINT
DISTANCE BETWEEN HOLE AND TANGENT POINT
4
4

D-3566-040 ASSEMBLY DETAIL

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

8

0.5

1.5

1.5

H

P

P

P

P

P

P

P

P

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

DESIGN	DRAWN BY
--------	----------

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

COPYRIGHT © 1996 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN	
--------	--

P4

CHECKED *W*

4

DATE _____

07.02.27

DRAWN BY

R

APPROVED

+

DART

DART AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

DRAWING NO

02580

205	SKIDTUBE ASSEMBLY
-----	-------------------

REV. D

SHEET 3 OF 3

SCALE

SCALE

NO. 145

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name Barday E
Joint Welding Procedure G+AW
Part number and Job number D250 634 011 / B37730A

TEST WELDS REQUIRED

BASE METAL Aluminium WELDING PROCESS tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>			
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>	
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>	
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>	
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>	

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 08.03.27 Qualifier Pat Duval